

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 82.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019230**Date Inspected:** 30-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Westmont Industries**Location:** Santa Fe Springs, CA.**CWI Name:** Ruben Dominguez**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Travelers**Summary of Items Observed:**

The Quality Assurance Inspector Sean Vance arrived on site at Westmont Industries (WMI) in Santa Fe Springs, CA, to randomly observe the in process welding, QC inspection and non-destructive testing of the Travelers.

Upon the arrival of the QA Inspector, the following observations were made:

Traveler Test Rack

On this date, the QA Inspector randomly observed WMI production personnel performing fitting, welding and cutting activities on various assemblies for the Traveler Test Rack.

Trolleys

On this date, the QA Inspector observed WMI production welders, Mr. Jose Rodriguez (WID # 3031) and Mr. Eutimo Lopez (WID # 3035) performing Flux Core Arc Welding (FCAW) activities on the Trolley link plates and assemblies. The QA Inspector observed that the welds appeared to be designated as fillet and that Mr. Rodriguez and Mr. Lopez appeared to be performing the FCAW in all positions, throughout the shift.

On this Date, the QA Inspector observed Smith Emery QC Inspector Ruben Dominguez continuing to perform Magnetic Particle Testing (MT) on the previously completed fillet and Flare Groove welds, for the Assembly A704-1. The QA Inspector then spoke with QC Inspector Dominguez and Mr. Dominguez explained that he was performing the testing, in accordance to the approved MT Procedure SE-MT-CT.D1.1-105, Rev. # 1 and the testing is currently being performed on 100% of the completed fillet and flare groove welds. Mr. Dominguez further explained that he had previously performed Visual Testing on the welds and the welds were acceptable, per AWS D1.1 2002 Visual Acceptance Criteria. The QA Inspector was later informed by QC Inspector Dominguez

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that no rejectable indications were found after testing and that an applicable Magnetic Testing report will be completed, per the contract requirements. The QA Inspector observed that the above mentioned testing appeared to be in compliance with the contract requirements.

SAS-EB Traveler

Fixed Stairs Section

On this date, the QA Inspector observed Mr. Dominguez performing Ultrasonic Testing (UT) on the previously completed weld repairs. The QA Inspector noted that these repairs were rejectable indications which were previously discovered by the QA Inspector, during random UT on the previously tested and accepted Complete Joint Penetration (CJP) weld joints. The QA Inspector noted that the weld joints were designated as # 173, # #165 and # 183 (R2 status), for Frame Assemblies 10-A237 and 11-B237. The QA Inspector noted that these were also designated as the CJP cover plates for the Primary Suspension Arm Assemblies. Initially, the QA Inspector observed Mr. Dominguez utilizing what appeared to be a 70 degree Lucite wedge coupled to a .500" (12 mm) diameter, 2.25 MHz transducer, to perform a shear wave inspection, on the above mentioned repairs. During observation, the QA Inspector noted that the scanning pattern being performed by Mr. Dominguez appeared to be in compliance with AWS D1.1 2002, Figure 6.24 and that the testing appeared to be 100% coverage. After testing, Mr. Dominguez explained to the QA Inspector that no rejectable indications were found and an applicable form SE-UT-D1.1-CT-104, will be completed to document the acceptable weld repairs.

E2/E3-EB Traveler

On this date, the QA Inspector observed WMI production welder Mr. Juan Jimenez (WID # 3059) continuing to perform Flux Core Arc Welding (FCAW) welding activities on the Frame Assembly identified as 8-B327, per the shop drawings. The QA Inspector observed throughout the shift, that the FCAW was being performed in various positions, on the connector plate and Tube Steel (TS) material fillet and flare groove welds.

The QA Inspector randomly observed that Smith-Emery QC Inspector Ruben Dominguez was present, during the above mentioned welding and fitting activities. During random observation, the QA Inspector observed that the applicable WPS's and copies of the shop drawings, appeared to be located near each work station, where the above mentioned welding and fitting activities were being performed. The QA Inspector randomly verified that the consumable material, utilized during the welding appeared to be in compliance with the applicable WPS and that the above mentioned welders were currently qualified for the applicable process and position of welding. The QA Inspector randomly observed QC Inspector Dominguez verifying the in-process welding parameters, including voltage, amperage, pre-heat and travel speed and the parameters appeared to be in compliance to the applicable WPS.

Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

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Inspected By:	Vance,Sean	Quality Assurance Inspector
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Reviewed By:	Edmondson,Fred	QA Reviewer
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